Work Order September-23-13	ID 107358 p 4 0 0	07358	*107	7358*				A "	SAF	2 Page 1
Revision ID:		*10*	Accept	*N900	<u>040</u>	100)* s	etup Start Stop	1.71	S1* S2*
Start Date: 9// Required Date: 9//	23/13 Start Qty: 2.00	*D* *7*		Cust Item I Customer:	D:				13	.7/
	Process Plan: MLJ	Date: 13-09-25	Tooling: _ SPC (Y/N):		ate:		F	tun Start Stop	1/7	R1*
Sequence ID/ Work Center ID	Operation Description	Date.	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D4005	В		•							
100			0.00							
100 Waterjet	Memo		0.00				10	0		Ae 13.10.0
FLOW CNC Waterjet	1-Cut as p Dwg Rev: Prog Rev:	er Dwg (D4005-13)								
	2-Deburr i	f necessary		·						
110	QC2- Inspect parts off	machine FAI/FAIB	0.00						;	
110 QC Quality Control	Мето		0.00				10	<u></u>		13.10-

NCR: Ye	es / No				WORK ORDER NON-C	CONF	ORN	MANCE / UP	DATE	QA Closed:	Dat	re:
Work Ordei	r:				DISPOSITION	\prod			AGAINST D	EPARTMENT,	-	
Part No	0				Rework Scrap Use-as-is		1	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	o				Work Order Update]		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	lni	tial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Desc	ription	Date	Verification	n QC Inspector
Doc/Data Equip/Tooling												
Operator							,					
Material		1										
Setup												
Other		İ				-						
Process												
Supplier											İ	
Training						1						
Unapproved												
					F	AULT	CATE	GORY				
Landin	g Gear			_	General	_				_		
	Bending				Bend		irain			Ovalized		Pressure/Forced
[Centre No	ot Conce	ntric to	o/s	BOM/Route	Шн	lardwa	ire	Ĺ	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Lltr	rspect	ion Incomplete	L	Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs		nstruct	tions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
ſ	Cuffs				Contamination		⁄lainte	enance		Part Moved	_	
Ī	Heat Trea	at			Countersink	\square	/lislabe	eled		Positioned V	Vrong	
ſ	Inspectio	n Strip in	Tube		Cut Too Short	\square	/lisread	d	<u> </u>	Power Loss/	'Surge	Other
Ţ	Ripples in	n Bend			Drill Holes		Offset		_			
Ţ	Torque V	Vaves in I	Extrusio	n 🗀	Drawing	П	Out of (Calibration				
†	Turning S	Sequence	<u> </u>		Finish	П	out of	Sequence				
Ì	Wave/Tw	vist in Tu	be		Folio	П	Outside	Dimensions				

DQA:

Date:

Work Ord September-23-1				*107	7358*					Page 2
Item ID: Revision ID: Item Name: Start Date:	D4005-041 Forward Floo 9/23/13	r Gutter Start Qty: 2.00	*2*	Accept	*N90002	4 010 ()* ፡	Setup St		IS1* IS2*
Required Date:	: 9/23/13	Req'd Qty: 2.00	*2*		Customer:					
Approvals:		an:	Date:	Tooling: SPC (Y/N):			1		tart *N	IR1* IR2*
Sequence ID/ Work Center I 120 *120* QC Quality Control	D	Operation Description QC8- Inspect parts - second Memo	ond check	Set Up/ Run Hours 0.00 27 9-89		ool # Plan Code	Accept Qty	Reject Qty	Reject Numbe	Insp. r Stamp
130 *130* Brake NC Brake NC		Bend as per dwg Memo Bend D400:	5-13 as per Dwg	0.00			-10-			S6 13/10
140 *140* QC		QC5- Inspect part compl	leteness to step on W/O	0.00 SV 0.00 B(C	17		10			

Quality Control

NCR: Y	'es	/ No				WORK ORDER NON-O	CON	IFORM	MANCE / UP	DATE			
											QA Closed:	Date	e:
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
	_	·				Rework]		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo					Scrap]		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
		•				Use-as-is	│ 		noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	NO					Work Order Update	ا ئ		Large Fab	Composite	<u> </u>	Supplier	
Root					Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
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Operator													
Material													
Setup	\Box												
Other			1										
Process -	Ш		1										
Supplier	Ш]										
Training													
Unapproved							<u> </u>						
						F	AUL	T CATE	GORY				
Landi	ng G	iear			_	General	_	ì		_	_	_	_
		Bending			<u>_</u>	Bend		Grain		L	Ovalized	L	Pressure/Forced
	Ц	Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa		L	Over/Under	tolerance	Temperature/Cure
	Ш	Cracks				Broken/Damaged		Inspect	on Incomplete	<u> </u>	Part Incorred	it _	Weld
	Ш	Crushed/	Crimped			Burrs	L	Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Ш	Cuffs				Contamination		Mainte	nance		Part Moved		
	Ш	Heat Trea	it			Countersink		Mislabe	eled		Positioned V	/rong	
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss/	Surge	Other
		Ripples in	Bend	•		Drill Holes		Offset					
		Torque W	laves in E	Extrusio	n [Drawing		Out of 0	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 107358 *107358* Page 3 September-23-13 11:48:59 AM *N900040100* Accept Item ID: D4005-041 Setup Start **Revision ID:** Stop *NS2* Forward Floor Gutter Item Name: Start Qty: 2.00 Start Date: 9/23/13 **Cust Item ID:** Required Date: 9/23/13 Req'd Qty: 2.00 **Customer:** Reference: Run **Tooling:** Process Plan: _____ Date: Approvals: Date: Stop Date: Date: SPC (Y/N): QC: Reject Sequence ID/ Tool ID Tool # Plan Accept Reject Insp. Operation Set Up/ Work Center ID Description Code Qty Otv Number Stamp **Run Hours** Weld per dwg A/R Aluminum rod Batch: M 133 77 0.00 10 A 13-10-23 *1/11* 0.00 Large Fab Memo 1- Weld D4003-13 tube to angle as per dwg D4005 Large Fab 2- grind flush as per dwg OC9- Inspect visual per QSI004- Fusion Welds 0.00 DAS (b) 13-10-23 *142* 0.00 OC Memo Quality Control

143

QC5- Inspect part completeness to step on W/O 0.00

QC : Memo

0.00

Quality Control

(10) 13-10-23

									DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	ONFOR	MANCE / UP	DATE			
									QA Closed:	Date:	
Work Orde	··			,	DISPOSITION			AGAINST DE	PARTMENT,	/PROCESS	
WOIK OIGE	··				Rework	1	Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	o.				Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
				-	Use-as-is	Ther	moforming	Finishing	1	re/Packaging	Other
NCR N	lo				Work Order Update]	Large Fab	Composite]	Supplier	
D4	1	T	ľ	Dosori	intion of work order undate	Initial	Λ.	ction	Sign 9.	1	<u> </u>
Root	Date	Step	Qty		iption of work order update or Non-conformance	Chief Eng		cription	Sign & Date	Verification	QC Inspector
Cause Doc/Data	Date	Step	Qty	<u>'</u>	or Non-comormance	Cilier Ling	, Desc	прион	Date	Verification	QC IIISPECTOI
Equip/Tooling											
Operator	\dashv										
Material											
Setup	-	1								:	
Other											
Process											
Supplier											
Training										ļ	
Unapproved											
					F	AULT CATE	GORY				
Landi	ng Gear				General			F	٦		1
	Bending			<u> </u>	Bend	Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route	Hardw			Over/Under	 	Temperature/Cure
	Cracks			_	Broken/Damaged	—	tion Incomplete	<u> </u>	Part Incorre	 	Weld
	—	/Crimped			Burrs	\blacksquare	tions incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs			<u> </u>	Contamination	├ ─┤	enance	ļ	Part Moved		
	Heat Tre			<u> </u>	Countersink	Mislab		<u></u>	Positioned V		1
	Inspection	on Strip in	Tube		Cut Too Short	Misrea	ıd		Power Loss/	'Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

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Page 4

September-23-			7		′.イ::::::::::::::::::::::::::::::::::::							r age 4
Item ID: Revision ID: Item Name:	D4005-04 Forward Flo			Accept	*N900	040	100)*	Setup	Start Stop	*NS	S1* S2*
Start Date: Required Date Reference:	9/23/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item II Customer:	D:						
Approvals:		Plan:		Tooling: SPC (Y/N):		nte:			Run	Start Stop	*NI *NI	₹1* ₹2*
Sequence ID/ Work Center 150 *150* HandFinish Hand/Finishing	ID	Operation Description Chemical Conversion C Memo	oat per QSI005 4.1	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Qt	y i	Reject Number	Insp. Stamp
155 *1.55* QC Quality Control		QC7-Inspect Chemical (Conversion Coat	0.00				<i>[</i> 0	ф	/3	3-11-6	DAS 34 9-89
*160 *160* Powdercoat Powder Coating		Gloss Grey (4.3.5.15) p Memo Start Time; Oven Temp Finish Tim	1:35 Perature: 390°	0.00				10	_ \$	<u></u>	3-//-7	DA: 34 98

												DQA:	Da	ate:	
NCR: Y	es/	/ No				WORK ORDER NON-	100	NFORM	/IANCE / UP	DATE		·			
		:										QA Closed:	Da	ate:	
Work Orde	ar.					DISPOSITION				AGAINST D	ÞΕ	PARTMENT,	/PROCESS		
WOIR Olde	-	<u>, </u>				Rework	1		Skid-tube	Crosstube			Water Jet	t 🗀	Engineering
Part N	lo.					Scrap	1 1		Machining	Small Fab		Pro	d. Eng. Coor	-	Quality
4 1	-					Use-as-is		Therm	noforming	Finishing		Rec/Stor	re/Packaging	<u>;</u>	Other
NCR N	۱o. ₋					Work Order Update]		Large Fab	Composite			Supplie	<u>-</u>	
Root					Descri	ption of work order update		Initial		tion		Sign &			
Cause		Date	Step	Qty	•	or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	<u>n</u>	QC Inspector
Doc/Data	Ш				ā										
Equip/Tooling			ļ				j								
Operator	Ш														
Material															
Setup	Ш							٠							
Other	Ш		ı												
Process			İ										<u> </u>		
Supplier	Ш		l				1								
Training															
Unapproved				<u> </u>		11 - 0.44						1			
							AUI	LT CATE	GORY						
Landi	ng G	iear			_	General		1		F-		7		_	7
	Ш	Bending			<u> </u>	Bend	\perp	Grain		_		Ovalized		\vdash	Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route	\perp	Hardwa	re			Over/Under		L	Temperature/Cure
	Ш	Cracks				Broken/Damaged		⊣ `	on Incomplete	·		Part Incorre		<u> </u>	Weld
	Ш	Crushed/	'Crimped		L	Burrs		-	ions Incomplete/	/Unclear		Part Lost/M	issing	L	Wrong Stock Pulled
		Cuffs				Contamination	L	Mainte	nance			Part Moved			
		Heat Trea	at			Countersink	L	Mislabe	led	. [Positioned V	Vrong	_	-
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	1			Power Loss/	'Surge	L	Other
1		Pinnles ir	Rond			Drill Holes		Offcet							

Out of Calibration Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 107358 *107358* Page 5 September-23-13 11:48:59 AM *N900040100* Accept Setup Start Item ID: D4005-041 Revision ID: Stop Forward Floor Gutter Item Name: Start Qty: 2.00 **Cust Item ID:** 9/23/13 **Start Date:** Req'd Qty: 2.00 Required Date: 9/23/13 **Customer:** Reference: Run Date: **Tooling:** Date: Process Plan: Approvals: Stop Date: SPC (Y/N): Date: QC: Tool ID Tool # Plan Reject Reject Insp. Set Up/ Accept Sequence ID/ Operation Number Stamp Work Center ID **Run Hours** Code **Qty** Qty Description QC3-Inspect Part Finish 0.00 170 DAS 10 *170* 27 0.00 9-89 Memo 131108 **Quality Control** Identify as per dwg & Stock Location: 5725/ 190 *100* 0.00 Packaging Memo Packaging 0.00 200 OC21- Final Inspection - Work Order Release MLJ 13-11-13 MLJ 13-11-13 *200* 0.00

Memo

Quality Control

										DQA:	Date:	
NCR: Y	Yes	/ No				WORK ORDER NON-C	ONFORM	MANCE / UP		QA Closed:	Date:	
Work Orde	er: _					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	_					Rework Scrap Use-as-is Work Order Update		Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	I				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	- 1	Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data	Ш											
Equip/Tooling	Ш		ļ									
Operator												
Material												
Setup	П											

Unapproved **FAULT CATEGORY Landing Gear** General Bend Grain Ovalized Pressure/Forced Bending BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Weld Cracks Broken/Damaged Inspection Incomplete Part Incorrect Crushed/Crimped Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Burrs Cuffs Contamination Maintenance Part Moved Positioned Wrong Heat Treat Countersink Mislabeled Misread Power Loss/Surge Other Inspection Strip in Tube Cut Too Short Drill Holes Offset Ripples in Bend Out of Calibration Torque Waves in Extrusion Drawing Turning Sequence Finish Out of Sequence Folio Wave/Twist in Tube **Outside Dimensions**

Other
Process
Supplier
Training

September-23-13 11:48:58 AM

Work Order ID:

107358

Parent Item:

D4005-041

Parent Item Name:

Forward Floor Gutter

Start Date: 9/23/13

Required Date: 9/23/13

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:B 10.05.03 as per ECN10-

IPP rev A 10.01.21 new issue Prelim EC verified by:DD IPP Rev:B 10.562 DD verified by:EC IPP Rev:C 12.03.07 as per dwg rev.b DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4003-13		Manufactured	No			141	Each	14.0000	1	67 ²	7 10-	12	
Fwd Fuel Gutter Line										EZ_/	2-10-0	9-	
				Location		Loc Qty	<u>L</u>	oc Code					
				ST083		5				- , , -			
				982	22	4			-	7			
				986	09	1			-				
				ST088		9							
				100	271	9				6			
M6061T6S.040 6061-T6 .040 Sheet		Purchased	No	Ţ.		100	sf	260.0760	0.42	0.88421	05 ————	Ae 1	3.10
				Location		Loc Oty	<u>L</u>	oc Code					
				MAT021		260.076						a d	
				m12	26350	260.076			12	6350		4,7	

							•		DQA:	Date:	•
NCR: Yes	/ No				WORK ORDER NON-C	ONFOR	MANCE / UP	DATE	QA Closed:	Date:	
Work Order:		.,_			DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.	14 4 4 A A A A A A A A A A A A A A A A A				Rework Scrap Use-as-is Work Order Update		Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause	Date	Step	Qty	i '	ption of work order update or Non-conformance	Initial Chief Eng		tion ription	Sign & Date	Verification	QC Inspector
Doc/Data											

Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Bend Grain Ovalized Pressure/Forced Bending BOM/Route Hardware Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Broken/Damaged Part Incorrect Inspection Incomplete Cracks Weld Crushed/Crimped Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Burrs Cuffs Contamination Maintenance Part Moved Positioned Wrong Heat Treat Countersink Mislabeled Power Loss/Surge Other Inspection Strip in Tube Cut Too Short Misread Drill Holes Ripples in Bend Offset Out of Calibration Torque Waves in Extrusion Drawing Turning Sequence Finish Out of Sequence Folio Wave/Twist in Tube Outside Dimensions

Equip/Tooling

DART AEROSPACE LTD	Work Order:	107358
Description: Angle	Part Number:	D4005-13
Inspection Dwg: D4005 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+0.006/-0.001	.376	į		V	JKM-01
1.67	+/-0.030	1.67	, -		V	
26.77	+/-0.030	26.77	_		Τ	JKM-06
4.00	+/-0.030	4.00	_		V	
1.25	+/-0.030	1.25	_		V	
2.22	+/-0.030	2.22			_ v	
2.26	+/-0.030	2.26	_		V	
1.87	+/-0.030	1.87	-		V	
3.70	+/-0.030	3.70			V	
4.12	+/-0.030	4.12	-		V	
9.08	+/-0.030	9.08	_		T	
9.13	+/-0.030	9.13	-		Τ	
0.040	+/-0.010	.037	_		ν	JKm-01
		,				
			DAS			

Measured by: Ae

Date: 13.10.05

Audited by: 27
9-89

Date: 13.10.05

Date: 13.10.05

Date: 13.10.05

A 10.08.03 New Issue P/O D4005-041 KJ	roved
KI CVX	1
B 13.05.08 Dwg Rev updated KJ Sky K	Δ

								•			÷	DQA:	Dat	e:		
NCR: Y	es	/ No					WORK ORDER NON-C	CON	VFORN	MANCE / UP	DATE	QA Closed:	Dat	٠		
DISPOSITION									QA Closed: Date: AGAINST DEPARTMENT/PROCESS							
Nork Orde	r:					1	ZISFOSITION AGAINST ZE									
Part N	Part No.						Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			Water Jet Prod. Eng. Coor. Rec/Store/Packaging			Engineering Quality Other	
NCR N	NCR No.						Work Order Update			Large Fab	Finishing Composite	, Rec/stor	Supplier		Other	
Root					Desc	rip	tion of work order update		nitial	Act	ion	Sign &		\Box		
Cause		Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	<u>.</u>]	QC Inspector	
oc/Data quip/Tooling perator laterial etup ither rocess upplier raining napproved													·			
FAULT CATEGORY																
Landir	Landing Gear General											_				
		Bending Centre Not Concentric to O/S					Bend BOM/Route Broken/Damaged		Grain Hardwa			Ovalized Over/Under tolerance			Pressure/Forced Temperature/Cure Weld	
		Crucks Cruchad/Crimpod					Burrs	<u> </u>	4 '	ction Incomplete		Part Incorrect Part Lost/Missing			Wrong Stock Pulled	
		Crushed/Crimped					Contamination	\vdash	4	tructions Incomplete/Unclear aintenance		Part Moved	331116		With Stock i diled	
		Cuffs Heat Treat					Countersink		Mislabe		· -	Positioned Wrong				
		Inspection Strip in Tube				-	Cut Too Short		Misread		-	Power Loss/Surge Other		Other		
		Ripples in					Drill Holes	\vdash	Offset		L_		o-	_		
				xtrusio	n Ì		Drawing		4	Calibration						
	Torque Waves in Extrusion Turning Sequence						Finish	Out of Sequence						,		

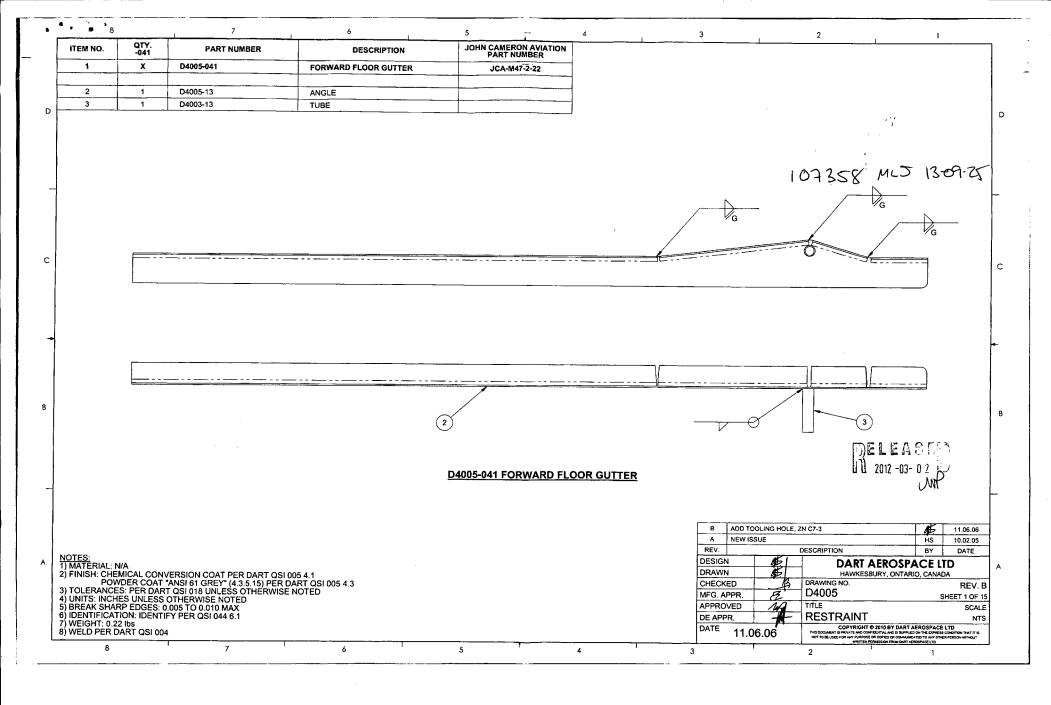
Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

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DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Skid-tube Crosstube Water Jet Engineering Rework Quality Part No. Machining Small Fab Prod. Eng. Coor. Scrap Thermoforming Finishing Rec/Store/Packaging Use-as-is Other NCR No. Work Order Update Large Fab Composite Supplier Description of work order update Sign & Action Root Initial Chief Eng QC Inspector Step Qtv or Non-conformance Date Verification Cause Date Description Doc/Data Equip/Tooling Operator Material Setup Other **Process** Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Ovalized Bending Bend Grain Pressure/Forced BOM/Route Centre Not Concentric to O/S Hardware Over/Under tolerance Temperature/Cure Broken/Damaged Cracks Inspection incomplete Part Incorrect Weld Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Ripples in Bend Drill Holes Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

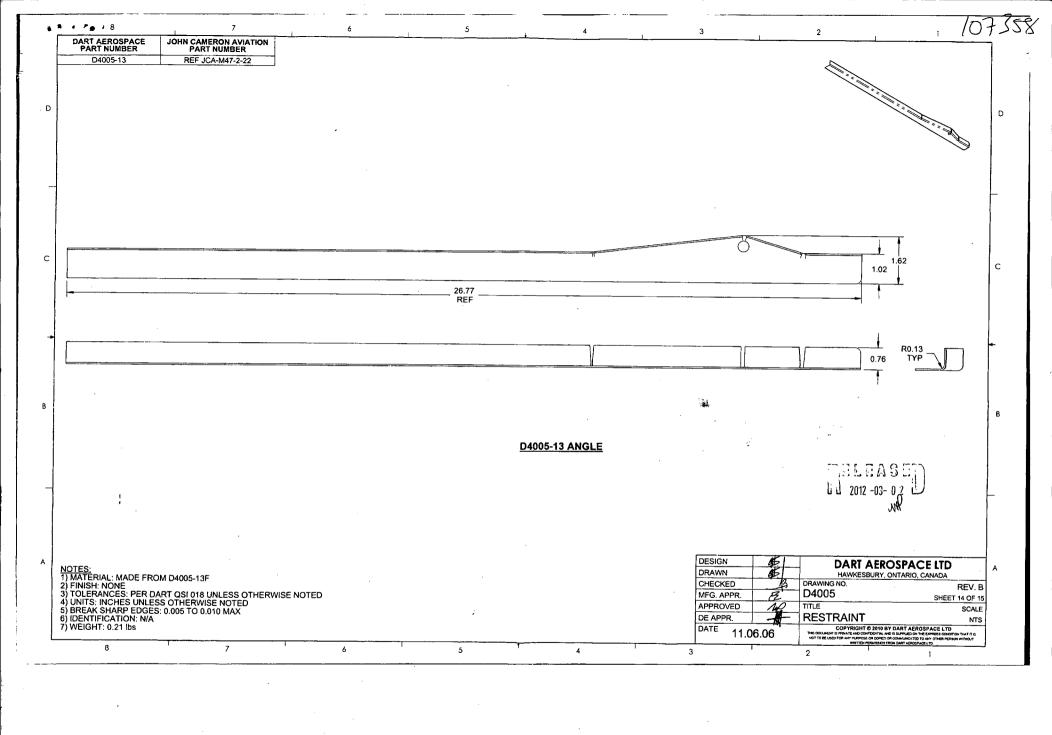
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

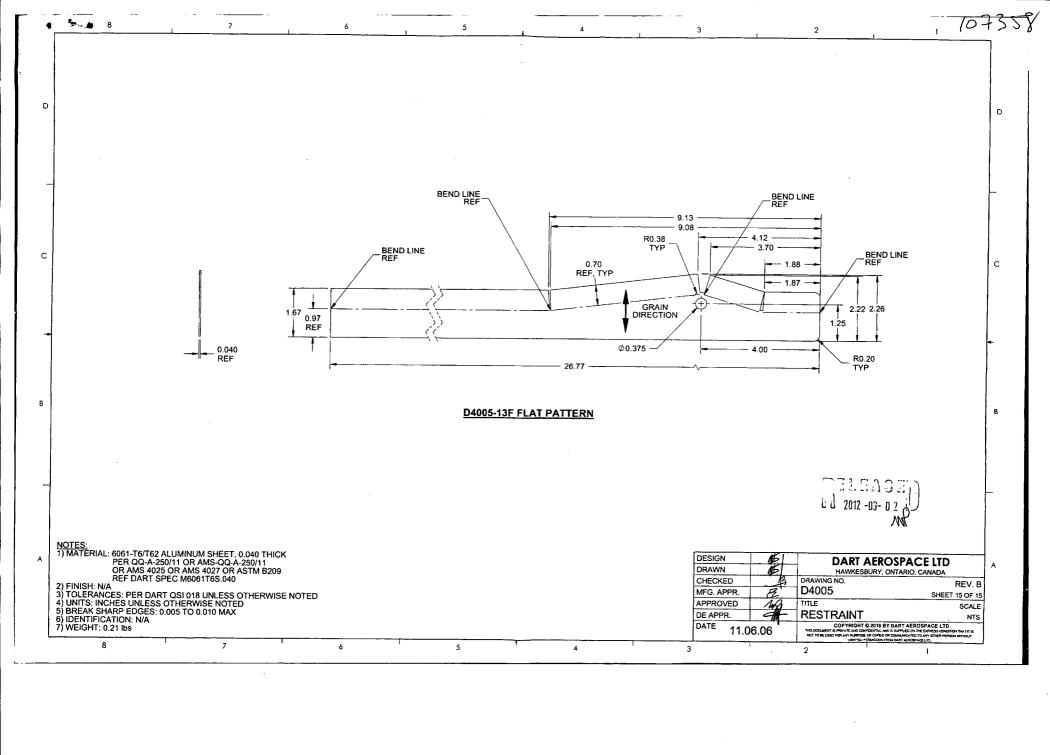
Folio



DQA: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE																
		1									QA Closed:	Date:				
Work Order: DISPOSITION								AGAINST DEPARTMENT/PROCESS								
Part No. Scrap Use-as-is								ļ	Skid-tube Crosstube Water Jet Machining Small Fab Prod. Eng. Coor. Thermoforming Finishing Rec/Store/Packaging				Engineering Quality Other			
NCR No.						Work Order Update]	Large Fab Composite			Supplier					
Root					Descri	ption of work order update		Initial Action			Sign &					
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector			
Doc/Data											!					
Equip/Tooling						•										
Operator										:						
Material							ļ									
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Other	Ш															
Process		ý									i i					
Supplier		1	·													
Training						·										
Unapproved			<u> </u>	<u> </u>				T 64TE								
FAULT CATEGORY																
Landing Gear General							_	Grain			Ovalized		7processes /Foresed			
	-	Bending			o/s	Bend BOM/Route	\vdash	-		<u> </u>	4	A-1	Pressure/Forced			
	<u> </u>	Centre Not Concentric to O/S Cracks				BOM/Route	\vdash	Hardware			Over/Under	 	Temperature/Cure Weld			
	-	⊣ ⊢				Broken/Damaged	\vdash	Inspection Incomplete			┥		Wrong Stock Pulled			
	_	Crushed/Crimped				Burrs Contamination	-	Instructions Incomplete/Unclea		Unclear —	Part Moved	2211B				
	├─	Cuffs			-	Countersink	\vdash	Maintenance			Positioned V	Vrong				
	-	Heat Treat				Cut Too Short	\vdash	Mislabeled			Power Loss/		Other			
	-	Inspection Strip in Tube Ripples in Bend			-	Drill Holes	-	Misread			Jeomei 1033/	Juige	Totalet			
	\vdash	Torque W		Evtrucia	<u>_</u>	Drawing	\vdash	Offset	Calibration							
	\vdash	Turning S			· ·	Finish	\vdash	-	Sequence							
	_	⊣				Folio	\vdash	- j	e Dimensions							
L	Wave/Twist in Tube					Trono		Tourside	י טוווופוואוטווא							



NCR:	Yes	/	No
INCIA.	163	,	110

											DQA;	Date	•
NCR: Y	es	/ No				WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:							:
Vork Orde	ŗ.	į				DISPOSITION				AGAINST DE			
Part No. NCR No.						Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fall Use-as-is Thermoforming Finishing			Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
INCK IN	· -					work Order opdate	ا ر ا		raige ran	composite	ł	Jupplier [_	
Root Cause						iption of work order update or Non-conformance		Initial Action nief Eng Description			Sign & Date	Verification	QC Inspector
perator aterial etup ther occess applier raining napproved													
		· · · · · · · · · · · · · · · · · · ·					AUL	T CATE	GORY			· · · · · · · · · · · · · · · · · · ·	
Landir	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion			Tube Extrusio	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misread Offset Out of 0	ion Incomplete ions Incomplete/Usenance eled d Calibration	Jnclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
	Turning Sequence Wave/Twist in Tube					Folio	-	ł	Sequence Dimensions				·

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G